

Order 12358



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2199-1

Job Sheet 189100



Part No: D2199-1

Job Qty: 2 pcs

Part Name: Struts, 19"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/5/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV F IPP B 02.06.10 Added finish NG/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Small Fab - 1 <i>18550</i>	2 pcs	2/5/19	4.11 0.55			Small Fab - 1	DAS <i>58</i>
							Small Fab - 2	<i>9-89</i>
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
120	QC 5	2 pcs	2/5/19	0.00 0.00			QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	DAS
							QC 5 - 38	<i>38</i>
							QC 5 - 42	<i>9-89</i>
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
130	Powdercoat - 2 White GI(S)-B4B	2 pcs	2/5/19	0.00 0.09			Powdercoat - 1 - B4B	
							Powdercoat - 2 - B4B	
							Powdercoat - 3 - B4B	
							Powdercoat - 4 - B4B	<i>BL 19-01-28</i>
140	QC 3	2 pcs	2/5/19	0.00 0.00			QC 3 - 10	

DART
AEROSPACE

1270 Aberdeen Street
Hawkebury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Container No: S146260

Part: D2199-1

Job No: 189100

Serial No/Batch: S146260

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/21/19

					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	DAS
					QC 3 - 68	FEB 04 2019 68
					QC 3 - 9	9-89
150	Packaging 3-1 - Stock - B4B	2 pcs	2/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	st 354
					Packaging 3 - 28 - B4B	★ FEB 04 2019
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS
160	QC 21 - SA	2 pcs	2/5/19	0.00 0.00	QC 21 - SA - 21	21 FEB 04 2019
Part Op 100 - (Punch ends and deburr as per dwg) Punch per Dwg. D2199 and Spec Control Dwg D2638 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: _____ FINISH TIME: _____ 140 - (QC3- Inspect Part Finish)						

150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.750W.049	304 Round Tube .750 X .049W	3.1000 ft (1.55 ea)	100-Small Fab - 1	5126573

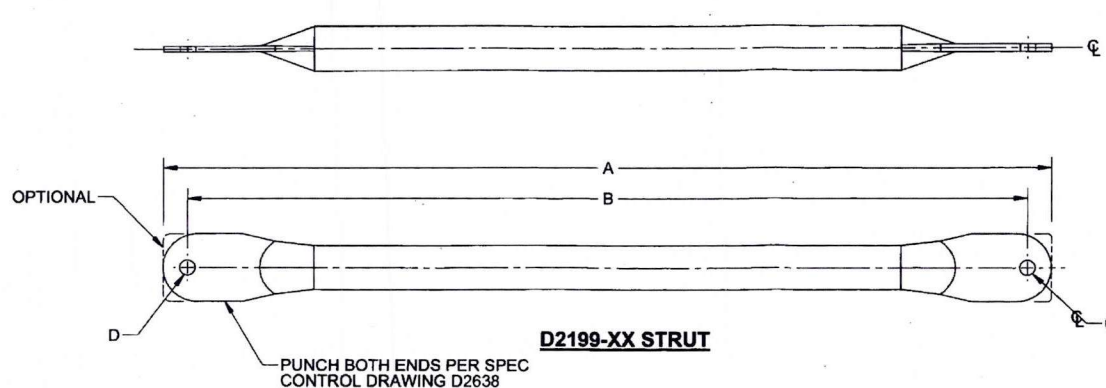
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304TR0.750W.049	3	282	0

Part Specifications

Specifications could not be found.

Plex 1/18/19 10:38 AM Dart.Macdonald.Dara



PART NUMBER	A	B	C	D	WEIGHT (LBS)	FINISH
D2199-1	18.80	17.50	Ø0.257	Ø0.257	0.56	NOTE 2
D2199-3	5.80	5.00	Ø0.257	Ø0.257	0.17	NOTE 2
D2199-5	22.64	21.84	Ø0.257	Ø0.316	0.69	NOTE 2
D2199-7	14.74	13.94	Ø0.257	Ø0.257	0.45	NOTE 2
D2199-9	16.52	15.72	Ø0.257	Ø0.257	0.50	NOTE 2
D2199-11	23.60	22.80	Ø0.257	Ø0.316	0.72	NOTE 2
D2199-13	15.96	15.16	Ø0.257	Ø0.257	0.49	NOTE 2
D2199-15	17.57	16.77	Ø0.257	Ø0.257	0.54	NOTE 2
D2199-17	28.05	27.25	Ø0.257	Ø0.316	0.86	NOTE 2
D2199-19	18.90	18.10	Ø0.257	Ø0.257	0.58	NOTE 2
D2199-21	10.80	10.00	Ø0.257	Ø0.257	0.33	NOTE 2
D2199-23	26.18	25.38	Ø0.257	Ø0.316	0.81	NOTE 2
D2199-25	19.93	19.13	Ø0.257	Ø0.257	0.61	NOTE 2
D2199-27	27.34	26.54	Ø0.257	Ø0.316	0.84	NOTE 2
D2199-29	21.11	20.31	Ø0.257	Ø0.257	0.65	NOTE 2
D2199-31	15.55	14.75	Ø0.257	Ø0.257	0.45	NOTE 3

△

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING Ø0.750 X 0.049 WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 REF DART SPEC. M304TR0.750W0.049
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 △
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D2199-XX" AND B/N BXXXXXX PER QSI 044, 6.5.
- 8) WEIGHT: PER CHART
- 9) MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER.

RELEASED

2015 FEB 04

REN 15-S2L 915-S2L

REV.	DESCRIPTION	BY	DATE
F	INCORPORATED E1 REFORMATTED AND REDRAWN. ADDED -31. ADDED GREY SANDTEX FINISH.	AJS	14.09.26
E	ADDED -23 AND -25 PER TSR A565M. ADDED TEMPLATE & SPEC CTRL. DWG REDRAWN IN CAD	KE	98.04.28
D	ADDED -21	N/A	N/A
C	ADDED -17 AND -19	N/A	N/A
B	ADDED -11, -13 AND -15	N/A	N/A
A	NEW ISSUE	JB	1993
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2199 STRUT DETAILS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS	REV. X	SHEET 1 OF 1
DATE	14.09.26	SCALE	NTS

APPROVED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																																	